

Work Order ID 81072

March-08-12 8:40:09 AM

81072

Page 1

Item ID: D2810-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Strut

Start Date: 08/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/03/08

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2810	Rev C								

100 0.00

100

NC BRAKE

Brake NC

Memo

0.00

Brake NC

1-Punch 304/316 SS Seamless Tubing 0.5" O.D. x 0.035" wall to length as per
Dwg D2810 and spec control Dwg D2727 using Jig DT8012

2-Deburr

(10) FF 12-03-12

110 0.00

QC5- Inspect part completeness to step on W/O

110

QC

Memo

0.00

Quality Control

5/26/12

(40)

120 0.00

Black Sandtex(Ref:4.3.5.7) per QSI005 4.3

120

Powdercoat

Memo

0.00

Powder Coating

START TIME: 9h30
OVEN TEMPERATURE: 320°F
FINISH TIME: 10h00

M115 128

10 2/28/12 12/03/16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Item ID: D2810-5

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Strut

Stop ***NS2***

Start Date: 08/03/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 22/03/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00

130

QC

Memo

0.00

Quality Control

10 6 12/03/16

140

Identify as per dwg & Stock Location: **ST 268** 0.00

140

Packaging

Memo

0.00

Packaging

(10x) Sp 12-03-16

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

12/3/19

12-03-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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NOTE: Date & initial all entries

Picklist Print

March-08-12 8:40:13 AM

Page 1

Work Order ID: 81072

81072

Parent Item: D2810-5

D2810-5

Parent Item Name: Strut

Start Date: 08/03/2012

Required Date: 22/03/2012

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP A04.11.30New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304TR0.500W.035		Purchased	No			100	f	256.5653	1.9175	20.18421			

M304TR0 500W 035

304 RD Tube .500 x .035W

**

①⑩ FF 12-03-12

Location

Loc Qty

Loc Code

MAT017

256.5652723

115535

0.913

116720

1.66068

117598

7.6415923

119160

4.79

119644

2.1209

120633

239.4391

20.18421

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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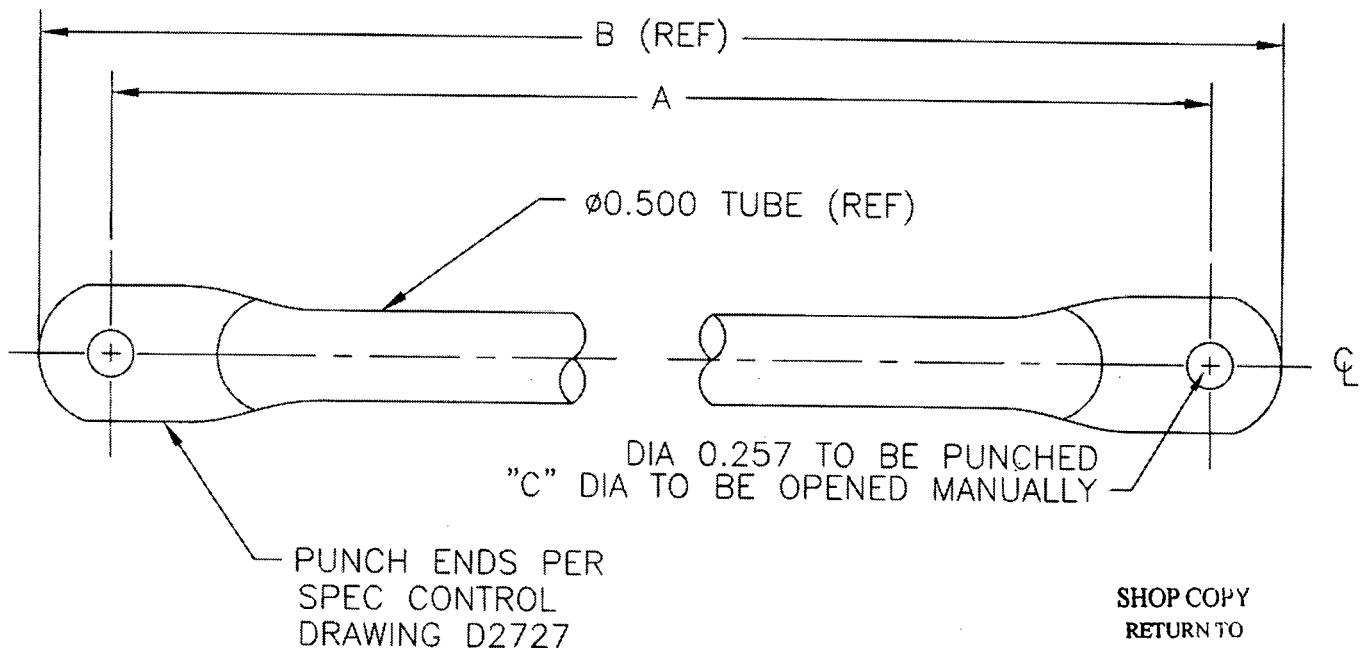
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2810	REV. C SHEET 1 OF 1
DATE 04.11.22		TITLE STRUT	SCALE NTS
A	00.11.08	NEW ISSUE	
B	03.09.11	ADD FINISH	
C	04.11.22	ADD -5	

RELEASE

05 03 11 *[Signature]*



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SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER

NO. 81072 MLJ
12/03/08

PART #	A	B	C
D2810-1	25.33	26.13	N/A
D2810-3	24.60	25.40	N/A
D2810-5	23.01	23.81	0.266

M.04

D2810-1/-3/-5

- 1) MATERIAL: AISI 304/316 STAINLESS STEEL TUBE, $\phi 0.500 \times 0.035$ WALL (M304TR0.500W.035)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) FINISH: POWDER COAT BLACK SANDTEX (4.3.5.7) PER DART QSI 005 4.3
- 4) ALL DIMENSIONS ARE IN INCHES

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